

File: Thursday, 15/01/2009 10:01:53 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SKIDTUBE ASSEMBLY LH
Job Number	: 44806		
Estimate Number	: 10262		
P.O. Number	:	Part Number	: D350636011
This Issue	: 15/01/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2750 REV F
First Issue	: / /	Project Number	: N/A
Previous Run	: 44801	Drawing Revision	: F
	Type : SKIDTUBES	Material	:
Written By	:	Due Date	: 20/02/2009
Checked & Approved By	: <u>JUD 09.01.15</u>	Qty:	1 Um: Each
Comment	: Est Rev:I 02.09.25 Rearranged procedure steps KJ Est Rev:J 06-03-23 As per Rev D JLM Est Rev:K 06-07.13 As per dsi9343 EC Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC Est Rev:M 08-04-22 update steps 4, 13 DD verified by:EC Est Rev:N 08-09-23 revF as per dwg DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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HJ for JUD 09/02/02



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

5 29/02/04

2.0	D26003BENT	Extrusion Bent
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-3-Bent	Extrusion (Bent)	<i>B43495</i>

DP 9-1-15

3.0	D2744	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: *B43495*
B42713 *BE 9-1-16*

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

DP 9-1-15

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 44806

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *m109560 BE 09/01/16*

10-Grind welds flush as per Dwg D2750 *BE 09/01/16*

12- Scribe batch# inside per dwg D2750 *BE 09/01/16*

9-1-15

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/01/16 (x)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/16 (x)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pm 09-01-19

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP

9-1-20

W/O:		WORK ORDER CHANGES					
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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 44806

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch:

B-44885

ALM 9-1-20



10.0

D34901

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

B-44796

ALM 09-01-21

11.0

D34903

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

B-42979

ALM 09-01-21

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch:

B-43110

ALM 09-01-21

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on
sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

ALM 9-1-20

W/O:		WORK ORDER CHANGES					
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Job Number: 44806

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch:

exp. date:

M109883
9-7-11

AWM 9-1-20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 8)

A/R Aluminum Rod

batch:

M110295 BR 9-1-22

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

11-Debur holes

pmc
09-01-22

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/01/23 (X)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/23 (X)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M. 09/01/23

(1X)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:20
320°F
9:50

M. 09/01/24

(1X)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

BR 09-01-27 (1)

W/O:		WORK ORDER CHANGES					
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Process Sheet

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 44806

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

ALS41032225

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Insert

Batch: 11109817

BR

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
1- Install inserts as per Dwg D2750

BR 09-01-27

① -

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: 43754

BR

22.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: 42982 43890

BR

23.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: 43459

BR

24.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: 43460

BR

25.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: 43890

BR
BR 09-01-27 ① -

W/O:		WORK ORDER CHANGES					
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Job Number: 44806

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0	D37943	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: 43892

BR

27.0	D353525	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 44060

BR

28.0	D353625	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 44061

BR

29.0	D35371	Wearpad
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch: 43346

BR

30.0	D36311	Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: 40909

BR

31.0	D3488041	Blade Fitting Assembly, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: 41206

BR

32.0	NAS1611010	O-RING
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

O-RING

NAS1611-010 batch: 110584 (6)

(or MS28775-010) batch: M110715 (2)

BR

X

W/O:		WORK ORDER CHANGES					
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Job Number: 44806

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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33.0	NAS1611013	O-RING
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

O-RING

batch: 106513

BR

34.0	D3492041	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 44343 (6)

BR

35.0	D3492043	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 44344

BR

36.0	AN3C5A	Bolt
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Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Bolt

Batch: M110584

BR

37.0	AN3C6A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M1108880

BR

38.0	AN6C44A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: 110105

BR

39.0	AN8C35A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: 110105

BR

BR 0901-27 ①-

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 44806

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

AN960C10L

washer



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

washer

Batch: 110139

BR

41.0

AN960C816L

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Batch: 110139

BR

42.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: 110180

BR

* 43.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: 109740

BR

44.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: 110450

BR

45.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"

batch: M 109539

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M 109883

EXP DATE: 09-11

BR
09-01-27
⑩

BR 09-01-27 ⑩

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-assemble o'ring as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 101223

5-Coat all exposed fasteners with "LPS Procyon" batch: 104251

BR 09-01-27 (1)

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/02 (X)

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

48.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 42222

49.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M109772

50.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M110139

51.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M108964

S 9/02/02 (1)

W/O:		WORK ORDER CHANGES					
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Job Number: 44806

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

52.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: 110468

53.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: 44886

54.0

D35321

Spacer



Comment: Qty.: 2.0000 (s)/Unit Total : 2.0000 (s)

batch: 44643

55.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

56.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

57.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-02-04

44806

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART N
X				D2750-0
	X			D2750-0
		X		D2750-0
			X	D2750-0
1	1	1	1	D2739
8	8	8	8	D2743
1	1	1	1	D2744
8	8	8	8	D2745
1				D2750-1
	1			D2750-2
		1		D2750-3
			1	D2750-4
1		1		D3488-0
	1		1	D3488-0
4	4	4	4	D3490-1
4	4			D3490-3
		4	4	D3490-5
8	8	8	8	D3492-0
8	8			D3492-0
		8	8	D3492-0
1	1	1	1	D3535-2
1	1	1	1	D3536-2
3	3	3	3	D3537-1
8	8	8	8	D3631-1
1	1	1	1	D3791-1
1	1	1	1	D3793-1
1	1	1	1	D3793-3
1	1	1	1	D3794-1
1	1	1	1	D3794-3
38	38	38	38	ALS4-103
34	34	34	34	AN3C5A
4	4	4	4	AN3C6A ⁴¹³
4	4	4	4	AN6C44A QTY (5) (ZN C8-1);
1	1	1	1	D3535-13/-35 (ZN C8-1);
38	38	38	38	D3536-13/-35 (ZN B8-1);
1	1	1	1	AN960C ¹¹);
1	1	1	1	UNDER FWD/AFT SADDLE REMOVED
4	4	4	4	AN960C ⁸ HARDWARE QTY UPDATED (ZN B8-1);
4	4	4	4	MS21043 ³ WARE UPDATED (ZN C1-8, 9, 10, 11);
1	1	1	1	(ZN A6-1);
4	4	4	4	MS21083 ⁸⁻⁰⁴³
4	4	4	4	NAS1515 ^{SS STEEL WEARPLATES;}

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PE
POWDER COAT WHITE (REF. 4.3.5.14;
BLACK ANTI-SKID PAINT AS INDICA
- TOLERANCES: PER DART QSI 018 UNLES
- UNITS: INCHES UNLESS OTHERWISE NOT
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 L
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER F
- FINAL CONFIGURATION SHOULD HAVE TH
MINIMUM YIELD TENSILE STRENGTI
MINIMUM ULTIMATE TENSILE STREI
- SPRAY INSIDE OF TUBE WITH A COAT OF
COAT ALL EXPOSED FASTENERS WITH LF
POWDER COATING WITH MEK DEGREASE
- SPACER AND PLUG INSTALLED SAME AS
- SPACER AND PLUG INSTALLED SAME AS

SS STEEL WEARPLATES;
TS; CHANGE INSERTS; ADD D3631-1;
AS1515H3L; REMOVE QTY (10)
JE D2741, QTY (2) AN960C816;
21083C8

ACERS FOR APICAL FLOATS;
9133/9157

INCORPORATE D2738 AND D2740
293 TO AN8-16A

DESCRIPTION	PH	DATE
	PH	08.07.16
	CB	07.05.17
	PH	06.01.05
	CP	98.11.18
	CP	98.09.01
	DS	98.04.16
	BY	DATE

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D2750** REV. F
SHEET 1 OF 11

TITLE **350 SKIDTUBE ASSEMBLY** SCALE
NTS

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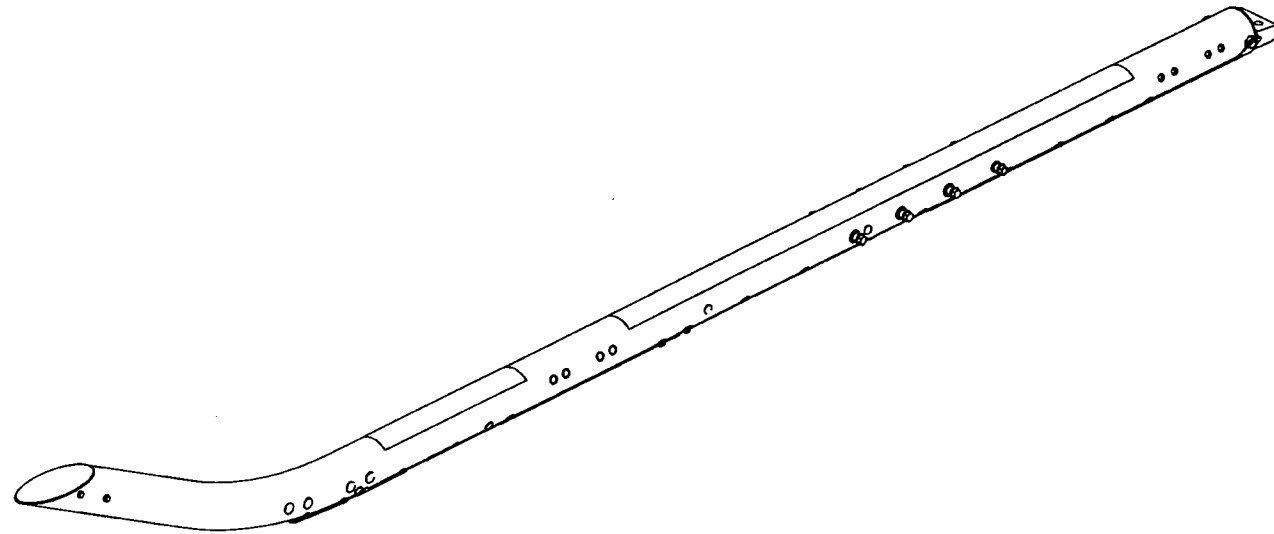
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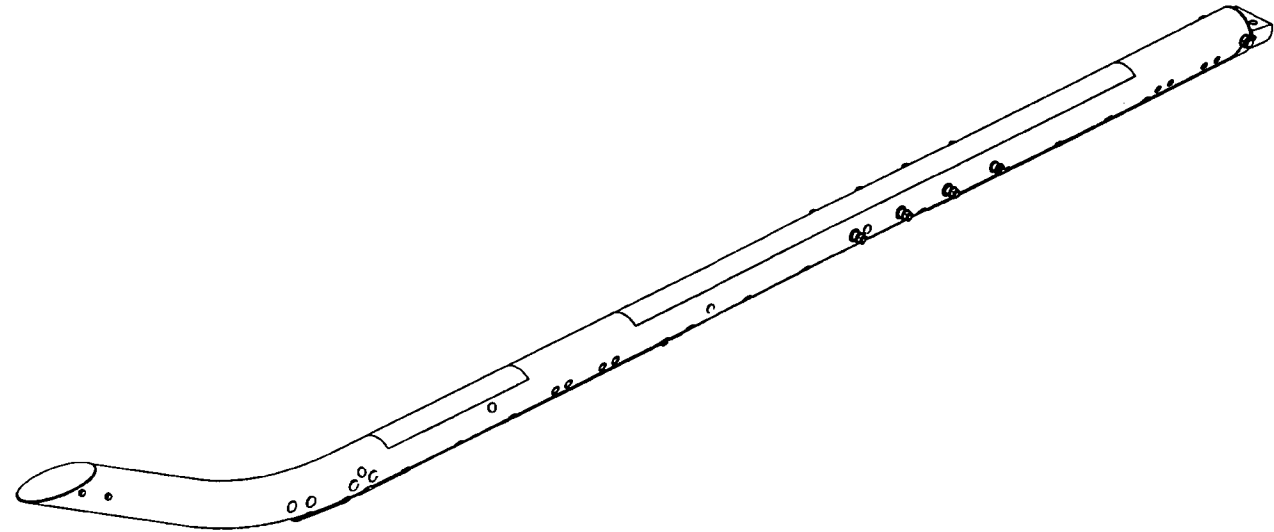
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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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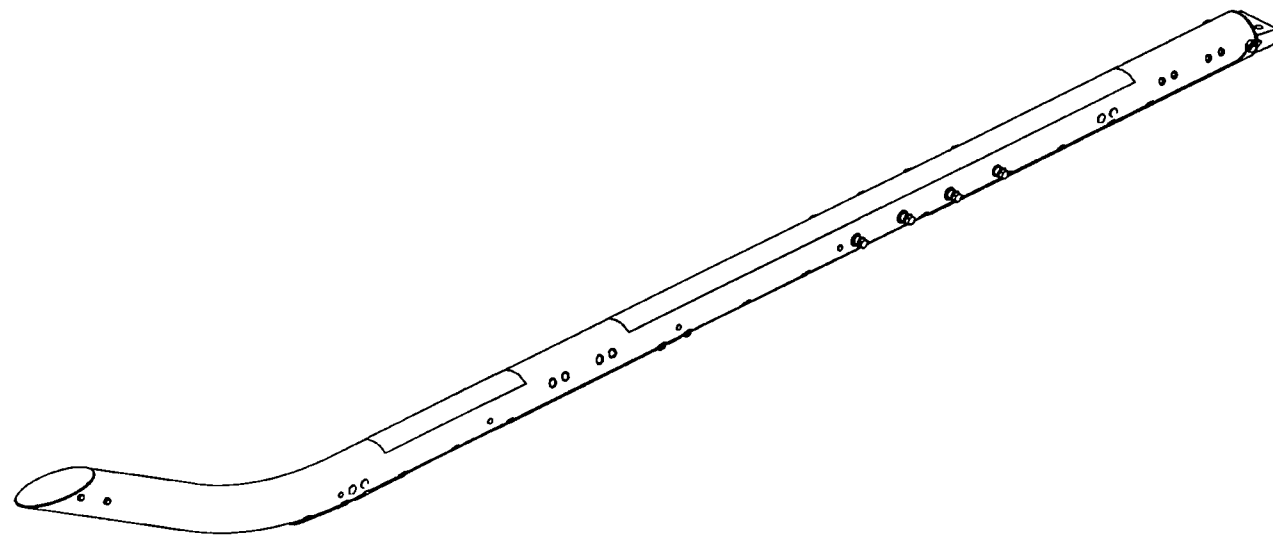
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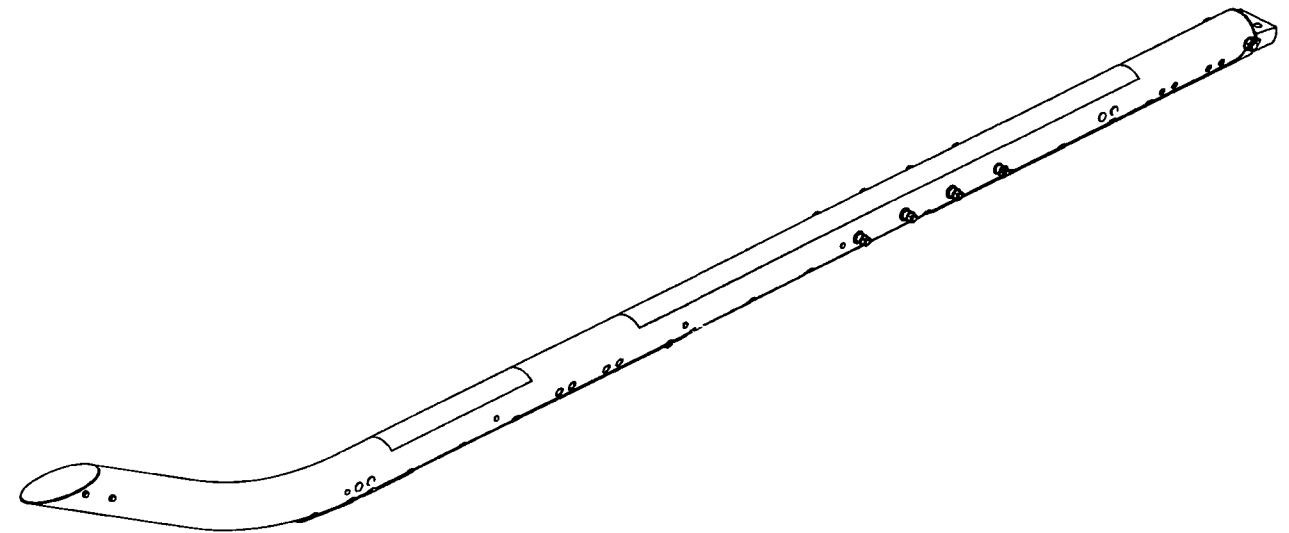
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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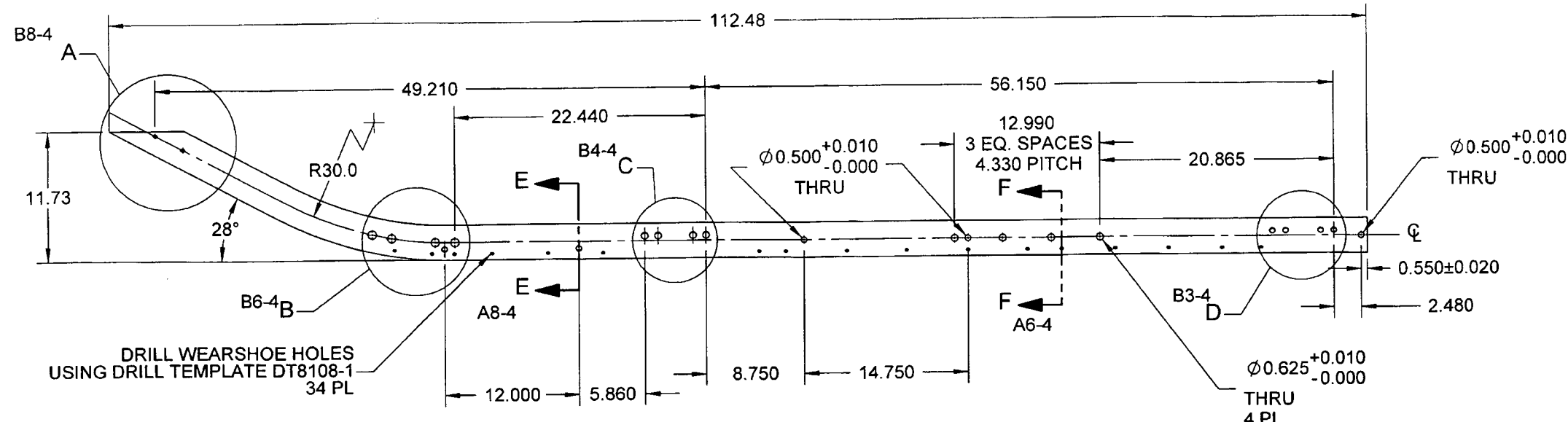
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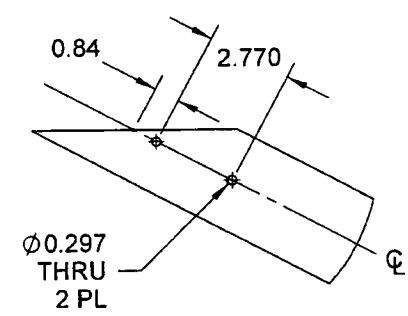
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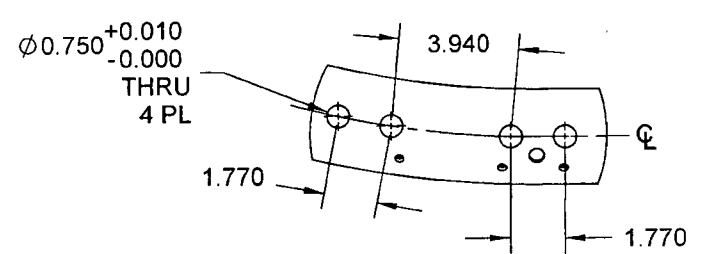
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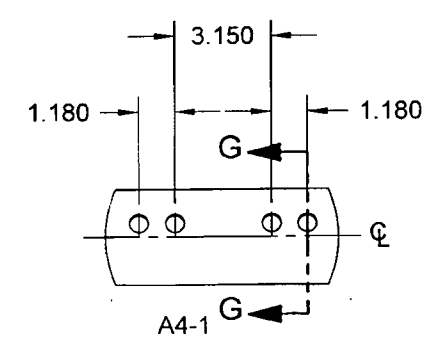
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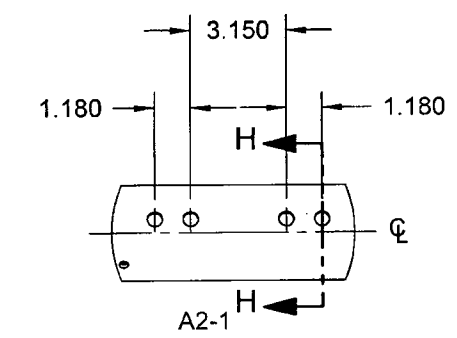
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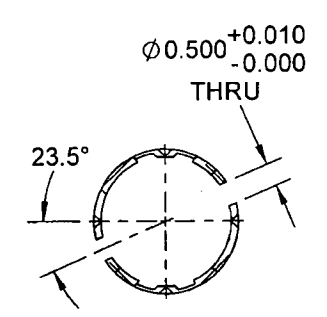
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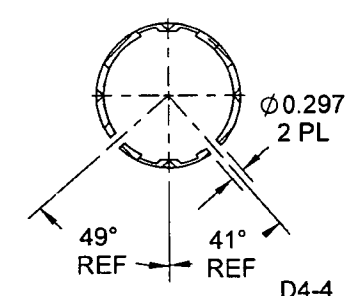
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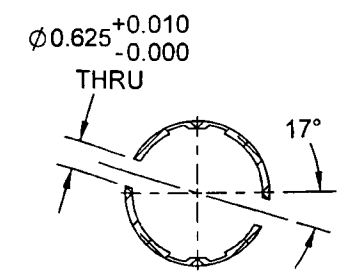
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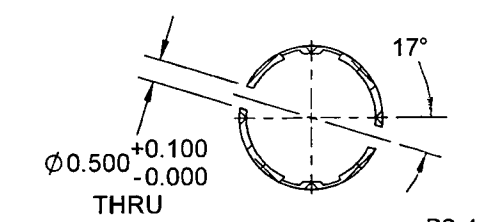
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



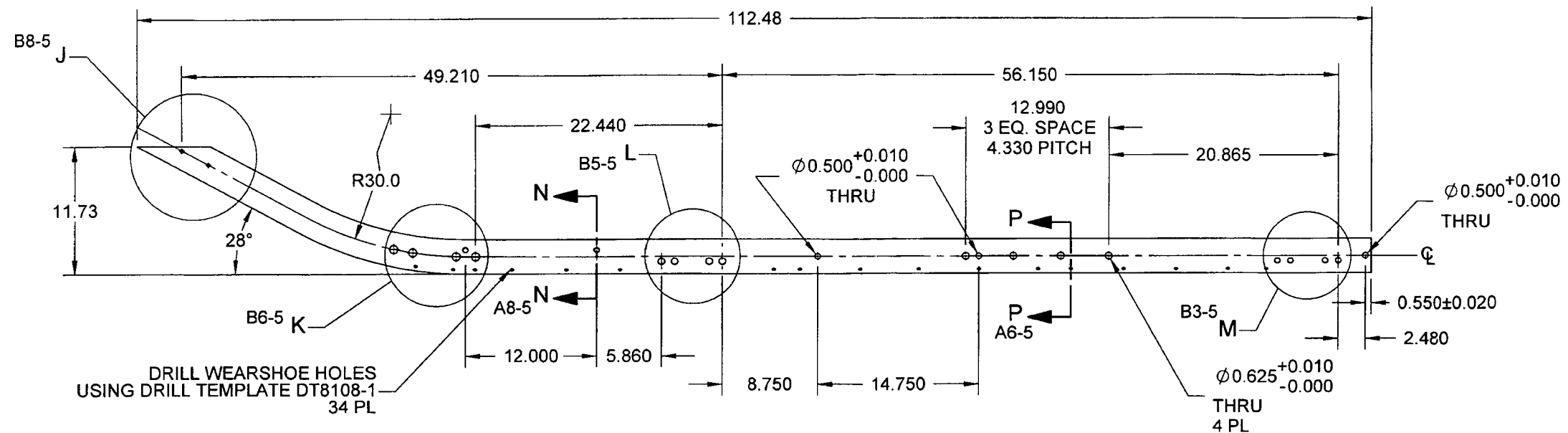
SECTION H-H
SCALE 3X, 4 PL

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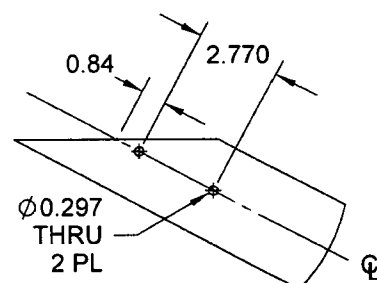
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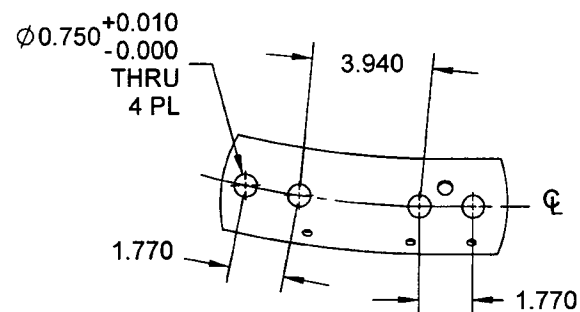
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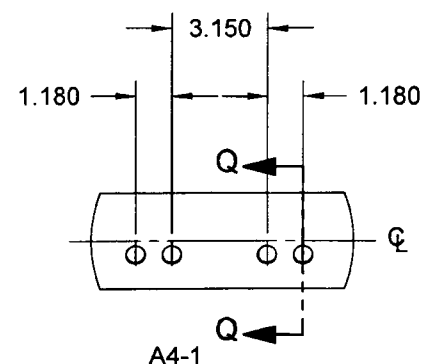
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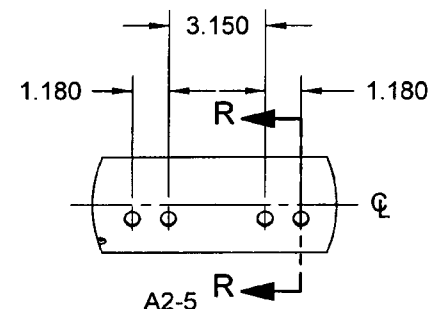
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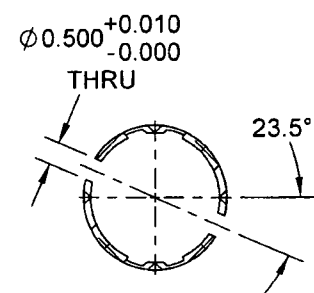
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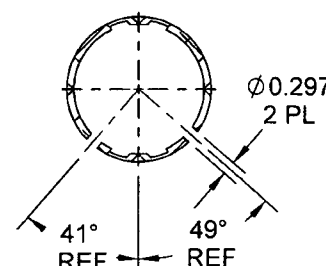
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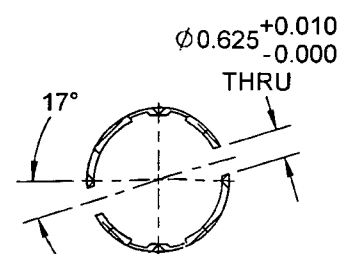
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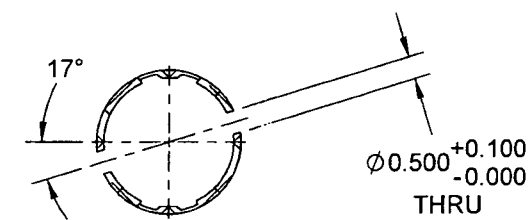
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SECTION P-P
C4-5
SCALE 3X, 17 PL



SECTION Q-Q
B5-5
SCALE 3X, 4 PL



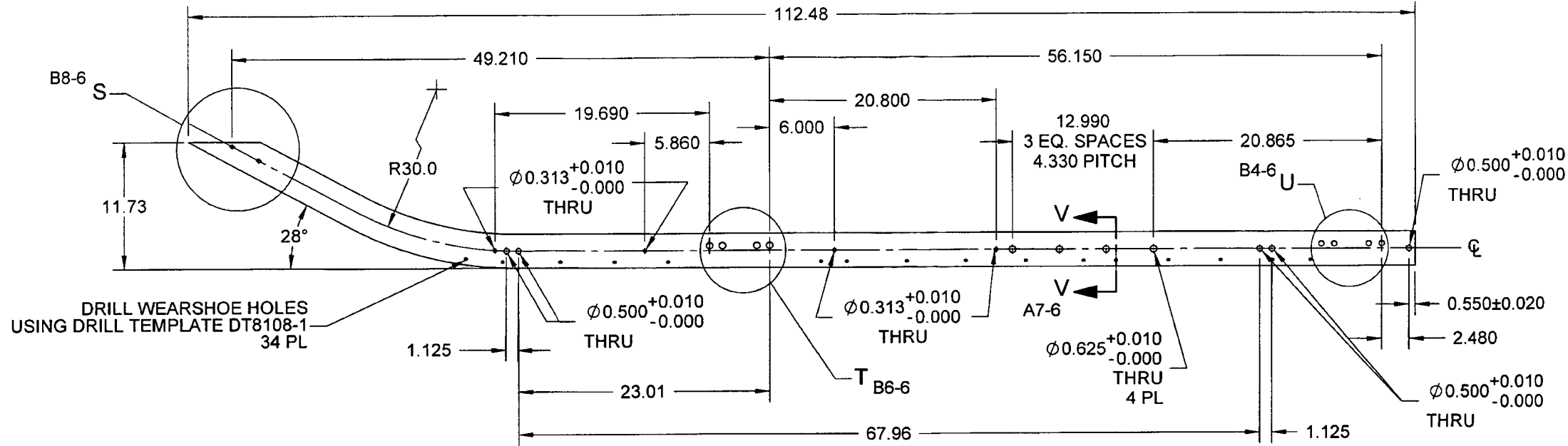
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SCALE 3X, 4 PL

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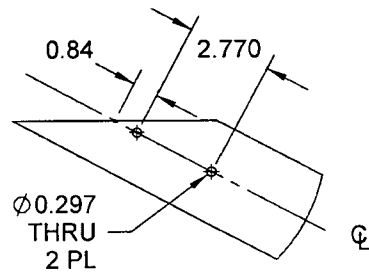
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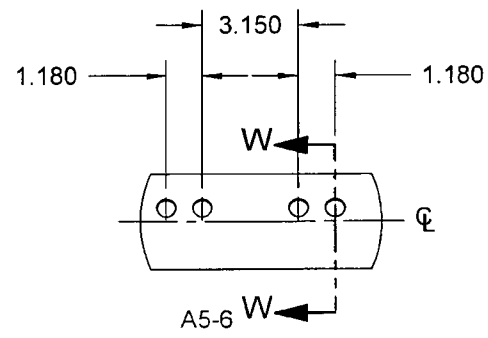
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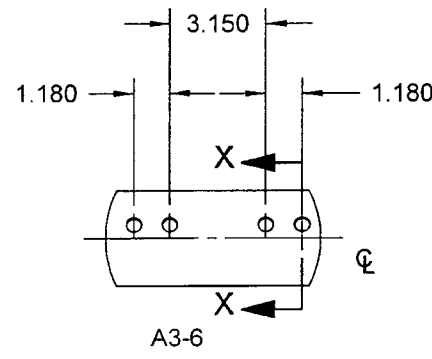
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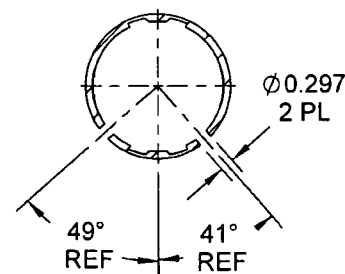
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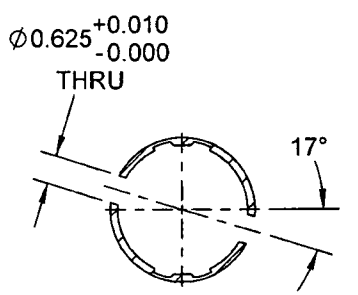
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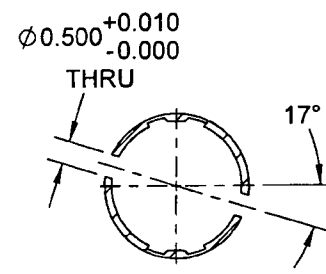
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SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

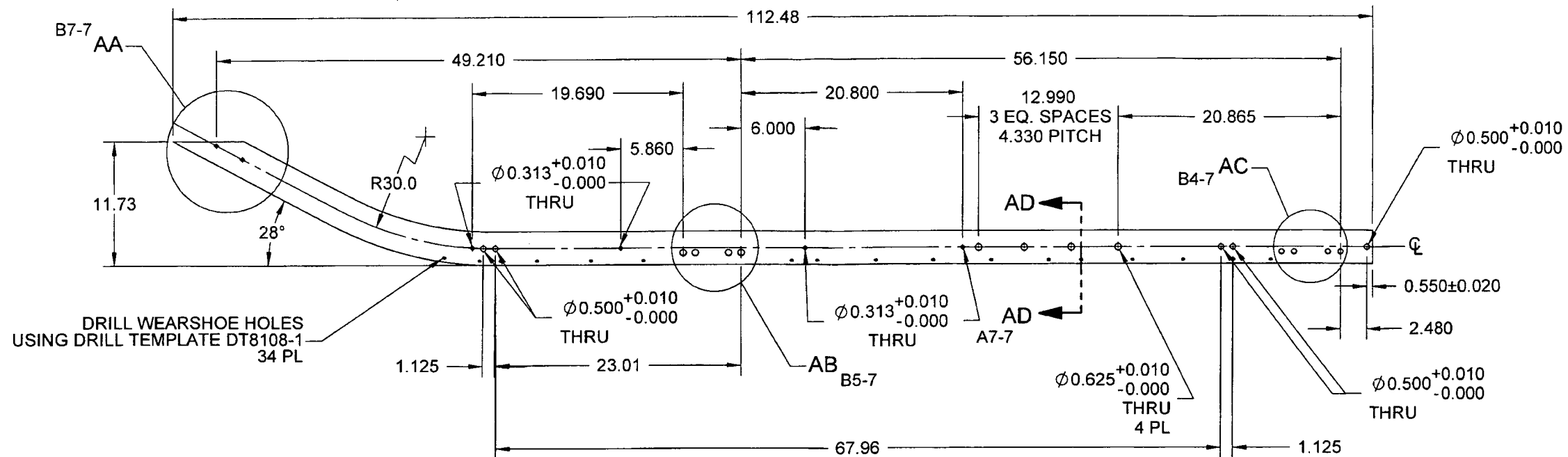


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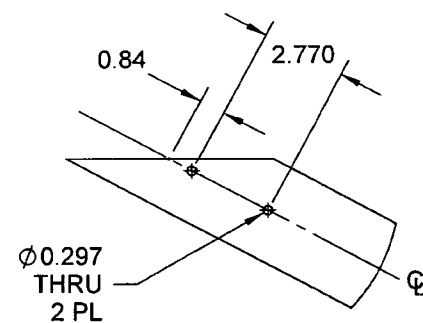
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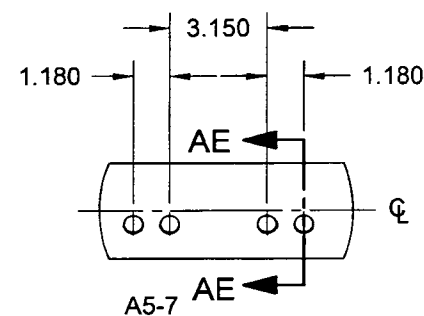
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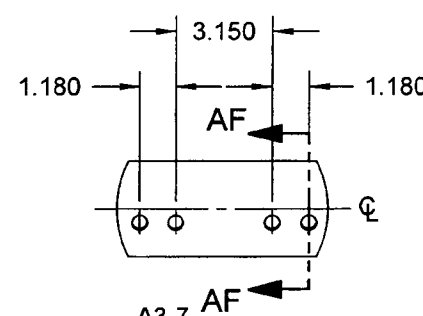
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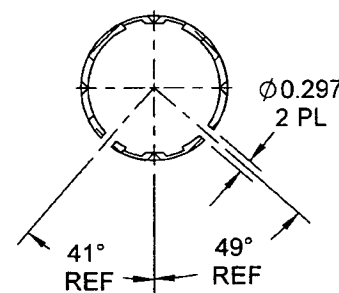
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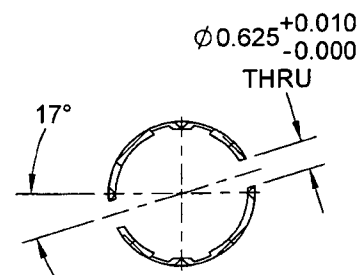
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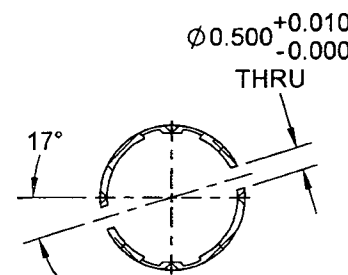
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SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

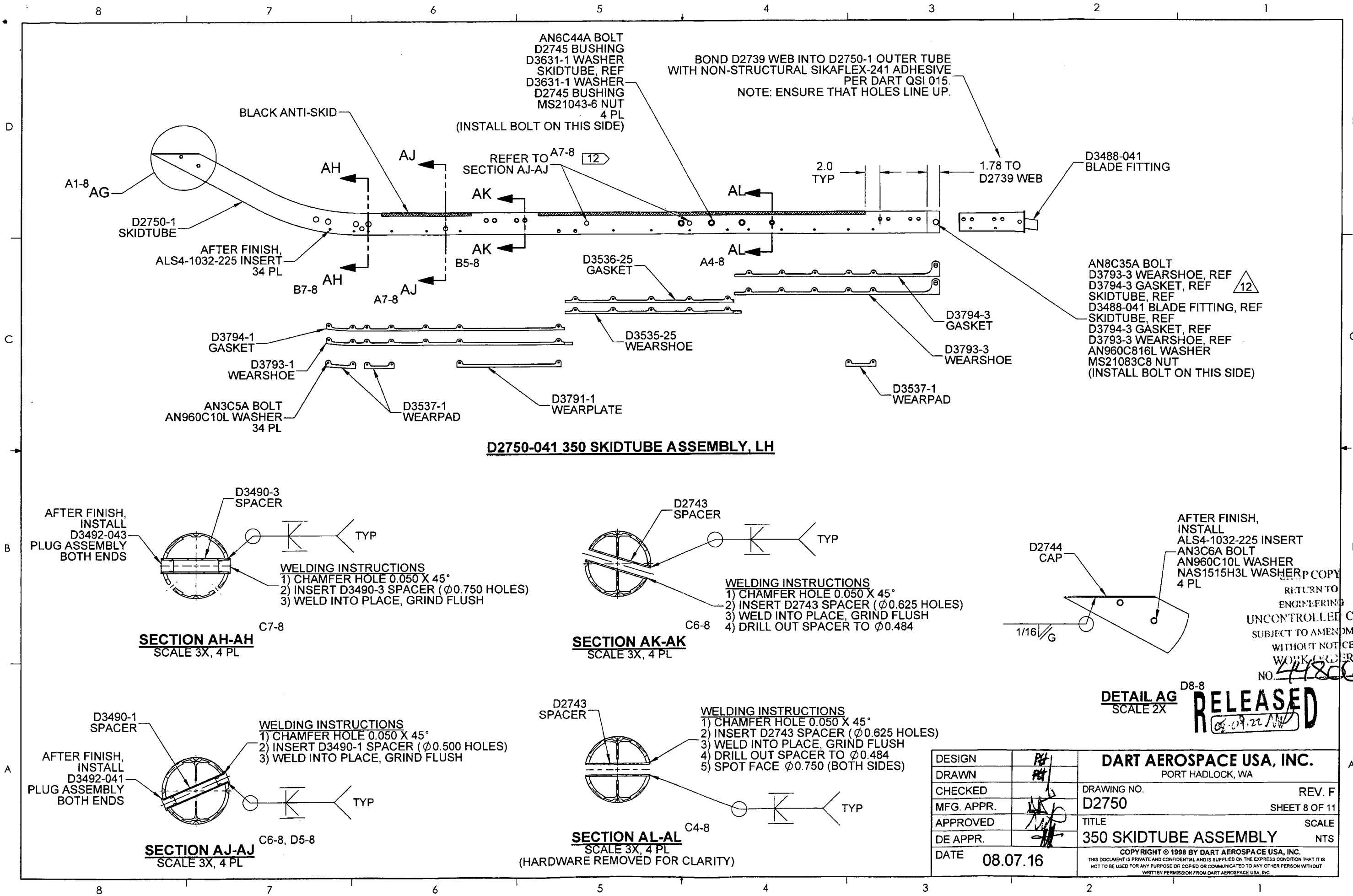


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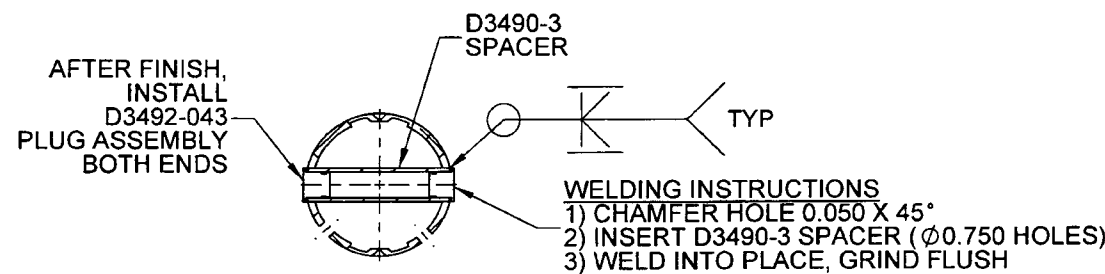
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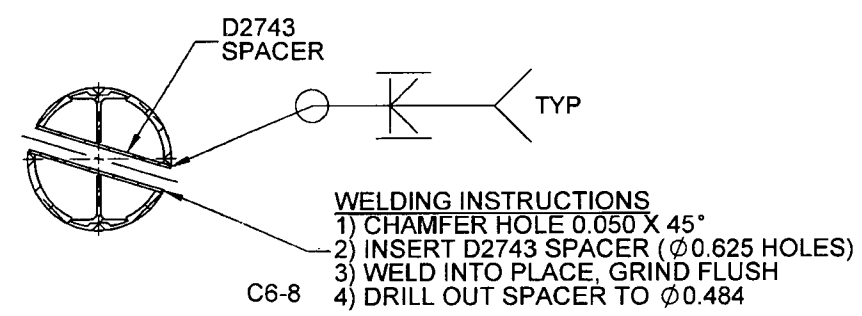
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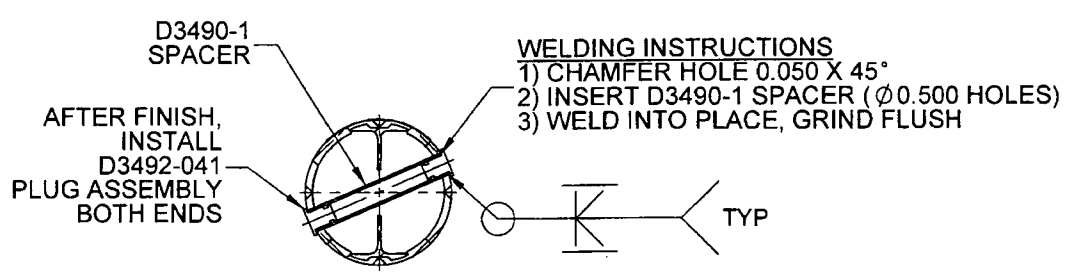
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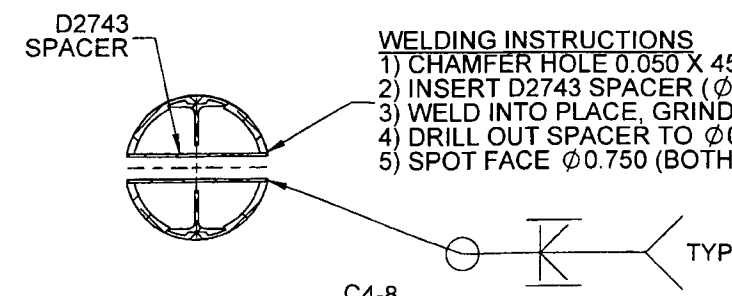
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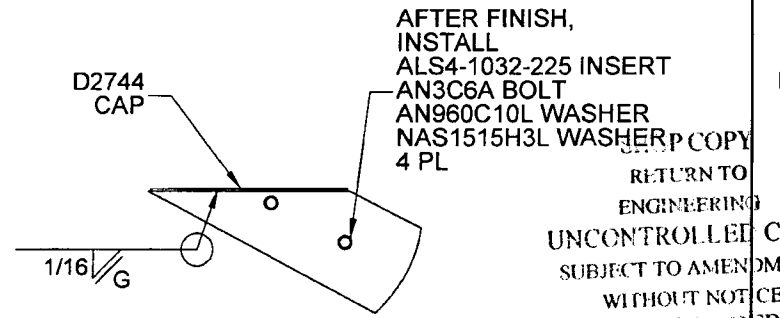
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SECTION AJ-AJ
SCALE 3X, 4 PL



SECTION AL-AL
SCALE 3X, 4 PL
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SCALE 2X

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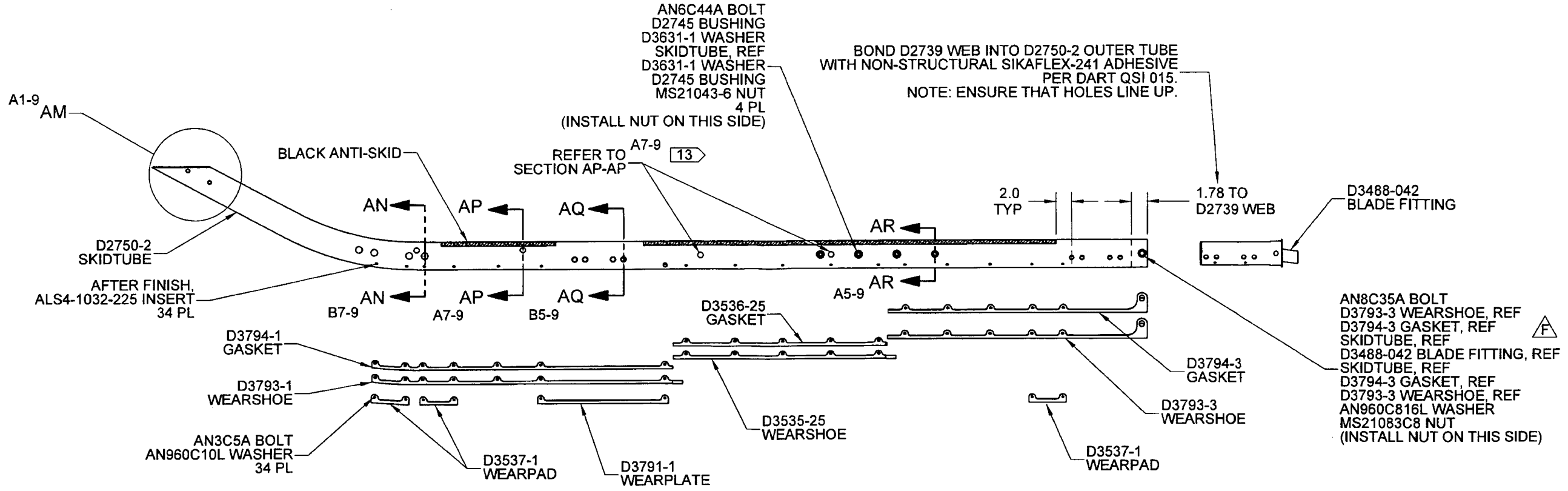
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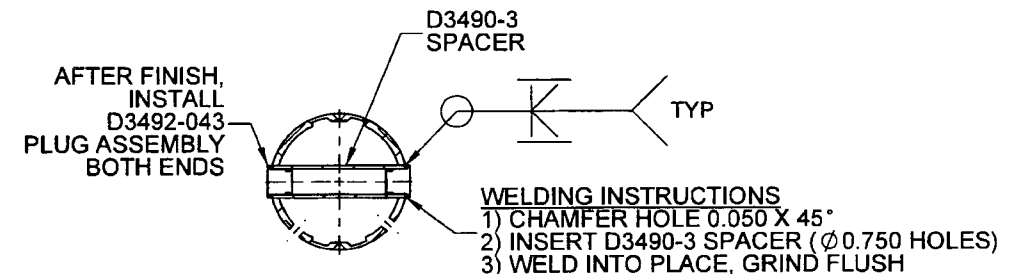
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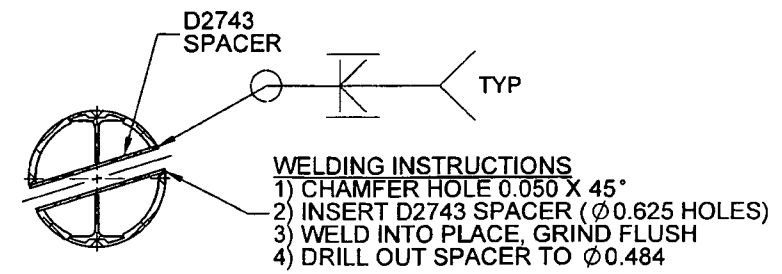
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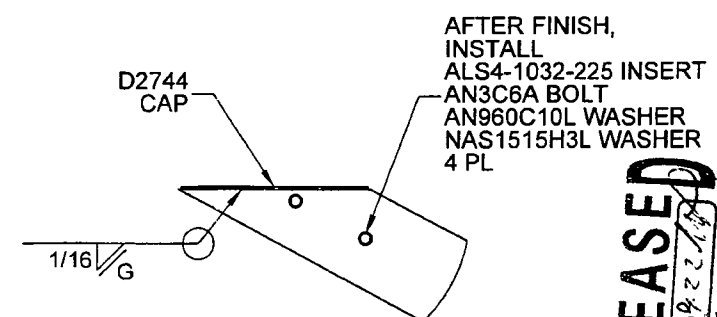
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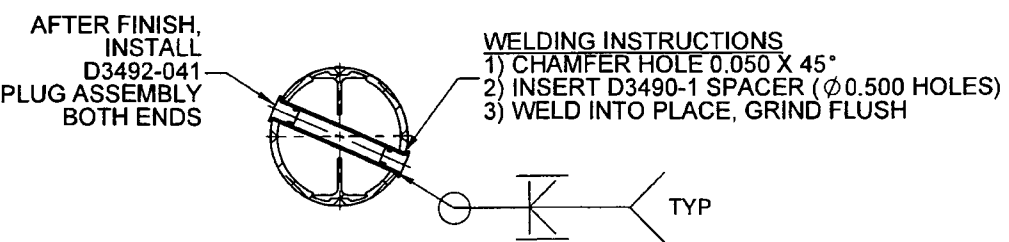
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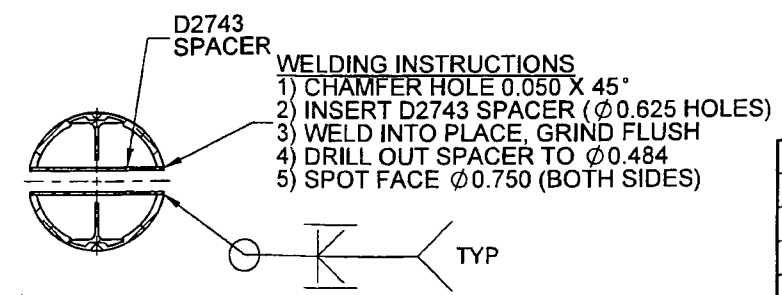
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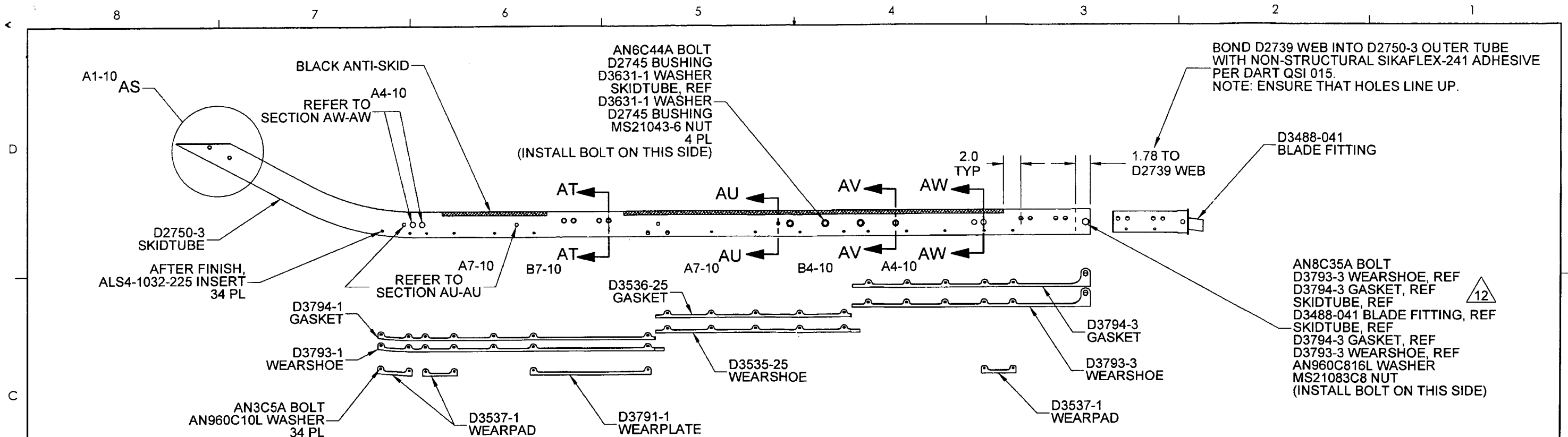
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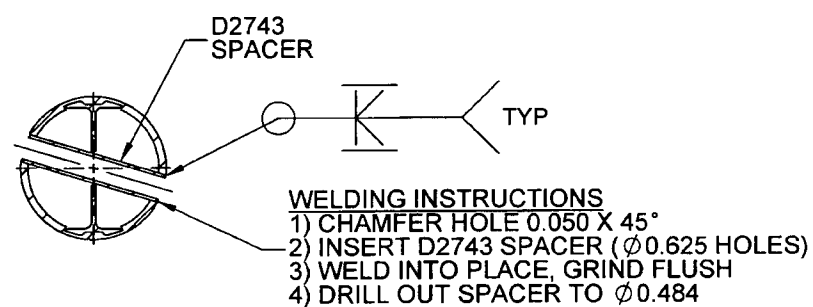
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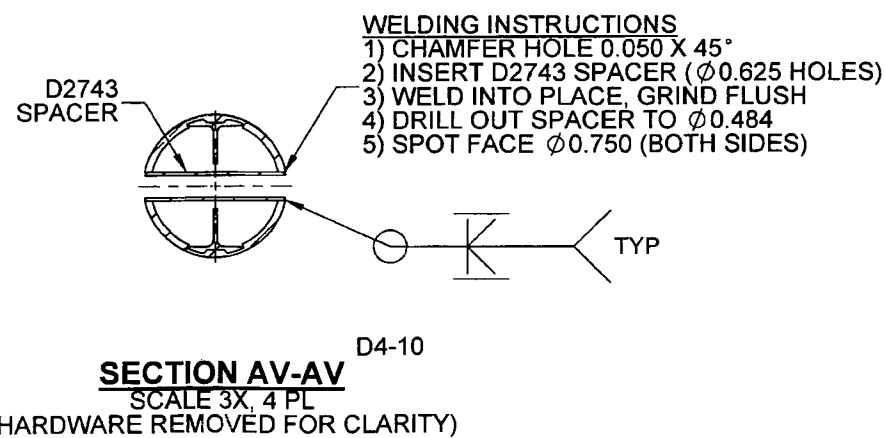
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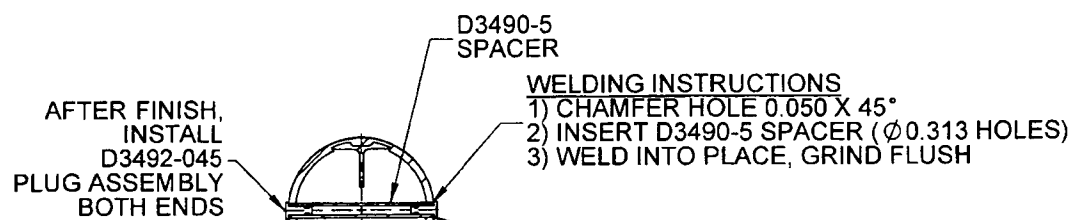
D2750-043 350 SKIDTUBE ASSEMBLY, LH



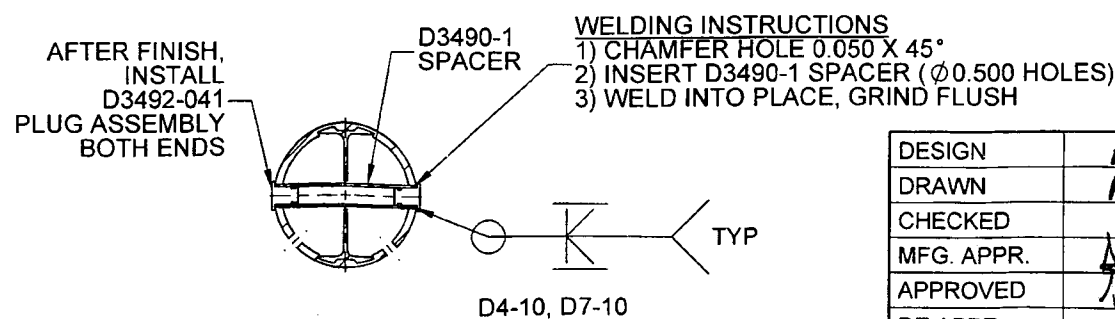
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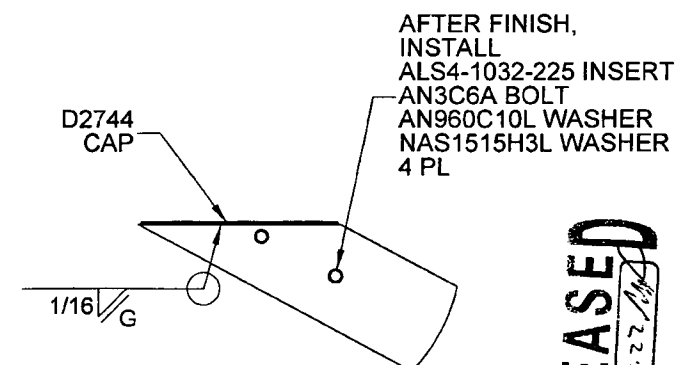
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SCALE 3X, 4 PL
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SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL



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NOTICE
ORDER
44800

NO. 189

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay ELLIOTT
Job number: 4480
Part number: D350.636
Description: 350 skid tube
Welding Process: Tig [] []
Base material: Aluminum
Current: AC [] DC []

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass [] fail []
pass [] fail []

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass [] fail []
pass [] fail []
pass [] fail []
pass [] fail []
pass [] fail []
pass [] fail []

Qualifier P. D. Dunch Date of Test Coupon 09-01-21

Welder Barclay Elliott Date of Test Coupon 09-01-21

The above named individual is qualified in accordance with AWS D17.1.2001 to weld